

Work Order ID 150421

Wednesday, August 24, 2016 11:54:43 AM

150421

Page 1

Item ID: D3561-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seal Insert Tool
Start Date: 8/19/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/24/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 24 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3561	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.05							
FLOW CNC Waterjet	1-Cut as per Dwg D3561 Dwg Rev: A Prog Rev: A 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS 38 9-89
SEP 26 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>Stop</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.07							
Quality Control									

DAS 6 4 9-89 OCT 14 2016

DAS 21 9-89 OCT 14 2016

DAS 21 9-89 OCT 14 2016

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Work Order update only ☐

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 150421

150421

Parent Item: D3561-1

D3561-1

Parent Item Name: Seal Insert Tool

Start Date: 8/19/2016

Required Date: 8/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A06.10.19New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	102.2369	0.0473	0.199158			

M304S11GA

304/316 0.125 Sheet

De 16/09/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	91.92998	
M129545	20.83998	
M129972	0.5	
M134284	2.79	
M135355	67.8	3
TPI	10.3069336	
M134604	10.3069336	

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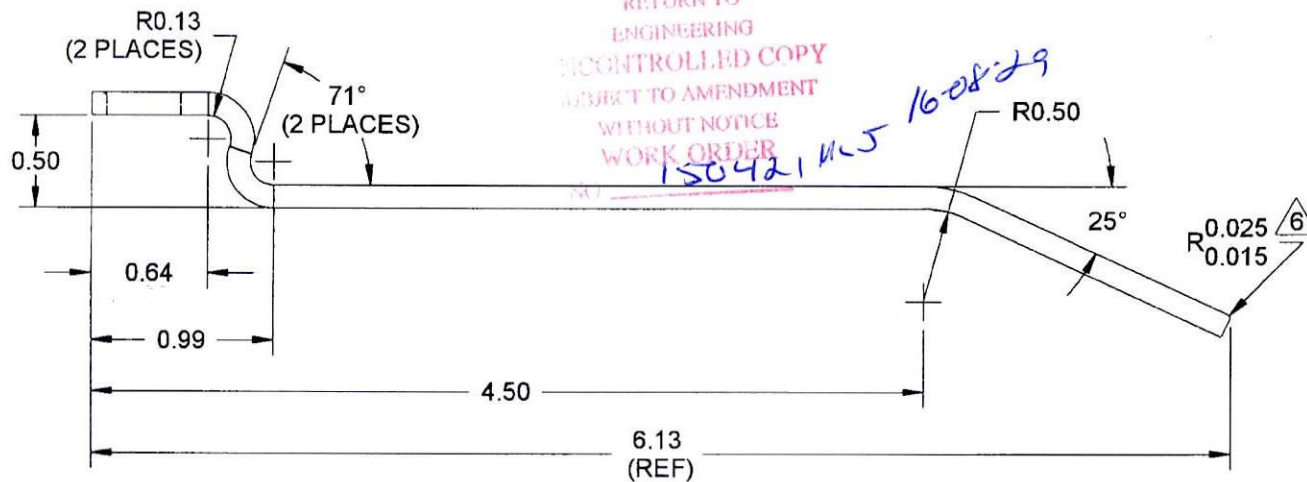
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	REV. A
CHECKED	APPROVED	DRAWING NO.
DATE	06.10.06	D3561
REV.	A	SHEET 1 OF 1
		SCALE
		1:1
		TITLE
		SEAL INSERT TOOL
		DESCRIPTION
		NEW ISSUE

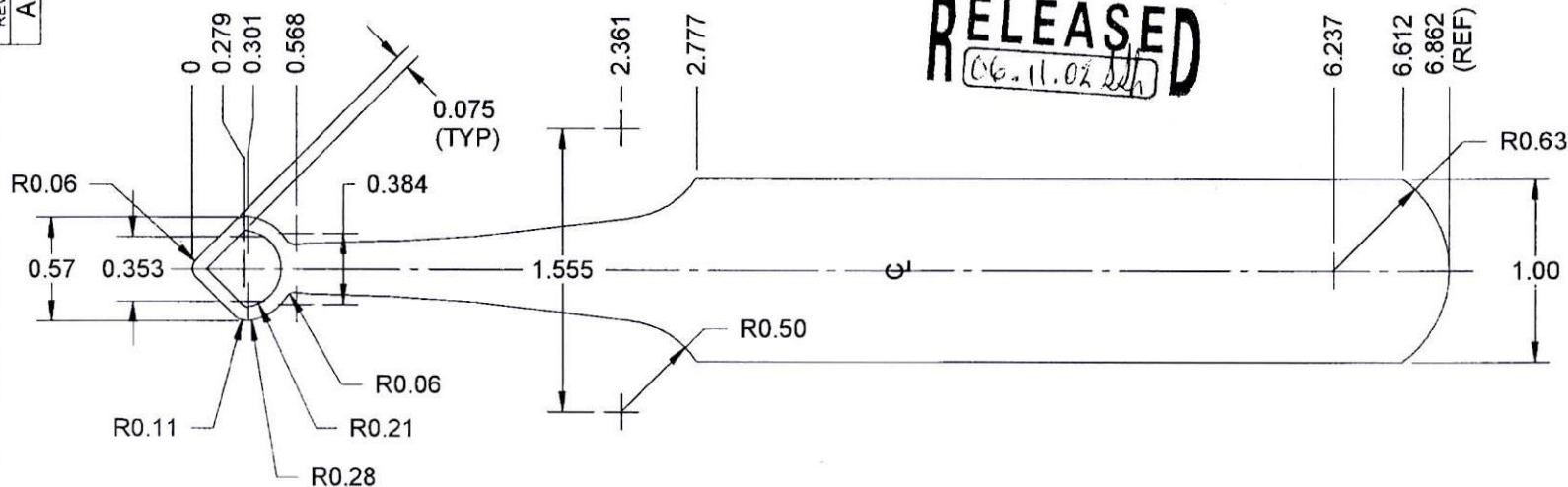
DART



D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



D3561-1F SEAL INSERT TOOL FLAT PATTERN

RELEASED
06.11.02

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